

Date: Monday, 22/06/2009 10:14:49 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HAT BIN (407), IVORY
<b>Job Number</b> : 48641A	
<b>Estimate Number</b> : 13676	
<b>P.O. Number</b> :	<b>Part Number</b> : D38351KIV
<b>This Issue</b> : 22/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3835
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : <i>cc</i>
<b>Previous Run</b> : 43953	<b>Material</b> : MKYD6185S125P362015
<b>Written By</b> :	<b>Due Date</b> : 24/06/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>MF 09-06-22</i>	
<b>Comment</b> : Est. Rev. A. 08.12.03 New Issue DL Est. Rev. B 09/04/15 Thicker Material DL verified by: EC Est REv C Add Colour Code 09/06/02 DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MKYD6185S125P362015	6185 KYDEX .125"
<b>Comment:</b> Qty.: 11.4264 sf(s)/Unit Total : 11.4264 sf(s) 6185 Kydex .125" Ivory <i>M 110426 BB 09/06/18</i>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
<b>Comment:</b> HAND FINISHING THERMOFORMING 1) Machine set up <i>BB 09/06/18 (X1)</i>		
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
<b>Comment:</b> HAND FINISHING THERMOFORMING 1) Cut sheet to required blank size <i>DL 09/06/18</i>		
4.0	THERMOFORMING	THERMOFORMING MACHINE
<b>Comment:</b> THERMOFORMING MACHINE Thermoform as per Dwg. D3835-1 and folio (FTA 407 Hatbin ) Dwg. Rev. <i>C</i> Folio Rev. <i>B</i> <i>BB 09/06/18 (X1)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (407), IVORY

Job Number: 48641A

Part Number: D38351KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

09/06/18 x1

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/06/18

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

09/06/18

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

09/06/18

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/24

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

IN THERMOFORMING.  
WAITING FOR PACKAGING

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3835-1 KIV PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: 10 - Date: 10.01.21

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>48641A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/21	7.0	Drawn Portion of HA Bin is Thin + Soft	<u>120</u> <u>045092</u> <u>09.06.21</u>	REINFORCE AFFECTED SECTIONS AND ATTACHED INSTRUCTION BASED ON TR-D407-781 REV 4	<u>BB</u> <u>09/06/21</u>	<u>S</u> <u>09/06/21</u>	<u>AA</u> <u>045092</u> <u>09.06.21</u>	<u>S</u> <u>09/06/21</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 48641A
Description:	Part Number: D3835-1K
Inspection Dwg: D3835-Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>W.L.</u>	Date: <u>09/06/18</u>
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>0.65"</u>	<u>±0.05</u>	<u>0.675"</u>	✓			
<u>0.80"</u>	<u>±0.05</u>	<u>0.831</u>	✓			
<u>1.00"</u>	<u>±0.05</u>	<u>1.024</u>	✓			
<u>1.20"</u>	<u>±0.05</u>	<u>1.222</u>	✓			
<u>0.050"</u>	<u>MIN.</u>	<u>0.103</u>	✓			
<u>0.030"</u>	<u>MIN.</u>					<u>See Attached</u>

Measured by: <u>W.L.</u>	Date: <u>08/26/24</u>
Audited by: <u>BB</u>	Date: <u>09/06/24</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

8 7 6 5 4 3 2 1

MIN FLANGE  
THICKNESS  
0.050

14.8  
REF

11.3  
REF

48.0  
REF

36.25  
REF

12.5  
REF

B2-1

54.1  
REF

1.00<sup>+0.05</sup>  
TYP  
1.20<sup>+0.05</sup>  
TYP  
0.80<sup>+0.05</sup>  
TYP

MIN THICKNESS IN  
DRAWN PORTION IS  
0.030

SECTION A-A B7-1  
SCALE 2X

RELEASED  
9/15/2005

D3835-1 HAT BIN  
(BELL 407)

48641 A

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9449 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3835-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3835-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3835-1KIV AND ADD STEEL GRAY P/N D3835-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3835	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	HAT BIN (BELL 407)	NTS
DATE	09.05.05	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

With reference to Test Report, TR-D407-781-1 Rev. A, the following may be performed to reinforce the drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.

Kydex 6185 reinforced with 9 oz cloth using Hysol 9330 A/B and ATH208  
Procedure:

- 1) Abrade smooth side of Kydex 6185 with scotchbrite and clean with acetone
- 2) Mix Hysol 9330 – Part A to Part B – 100% to 33% by weight in accordance with manufacturer's instructions

Hysol 9330 (2 part system)

BATCH # M 112099

- 3) Mix item 2) with ATH208 (Aluminum TriHydrate) at 50% by weight

ATH208

BATCH # M 110065

Ex:

100 grams of Hysol 9330 Part A + 33 grams of Hysol 9330 Part B = 133 grams of Hysol 9330

Therefore, use 133 grams of ATH208

- 4) Saturate 1 layer of 7781 9oz glass Cloth (item # FG778150550ROL) with mixture of Hysol 9330 and ATH208

9oz glass Cloth

BATCH # M 111166

- 5) Apply item 4) to reinforce drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.
- 6) QC 5

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